

**D4931-5**
Job Sheet 172555**Ship Via:**

https://www.plexonline.com/78fdcde4-9be4-4ea0-85ad-1edf0724c16c/Plexus_Control/Report_View/Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=True... 1/1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

QA Closed: **DAS**
53

Date: **June 14/19**

Work Order: **172555**

Part No. **04931-5**

NCR No. **19-7119**

Date: **18-03-14**

Step #: **112**

QTY Effective: **1**

MRB (Q51042) Approval

PD 18-3-15

Description Work Order Deviation

Disposition

The holes spacing 1.025" is 1.050"
center drill was off center.

Scrap destroy no replace.

Completed By

JL.-L
18-03-14

Lead hand / Supervisor
Approval Verification

B.F 18-03-15

QC / QA Coordinator
Approval

PD 18-3-15

Root Cause

Environment	No Re-verification
Design	☒ Operator
Doc/Data	☐ Offset/Setup
Equip/Tooling	☐ Supplier
Handling/Pre	☐ Training
Material	☐ Use for Testing
Internal Transport	☐ Poor Information
Tribal Knowledge	☐ Rushing
LOA	☐ Product Improvement
Substation	☐ Process Improvement
Past Expiry Date	☐ Manufacturing Process
Misidentified	☐ Past Due

FAULT CATEGORY

Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Bending	Set-up	Folio/Program	Outside Dimensions
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Cuffs	Contamination	Out of Sequence	Part Moved
Crushing	Countersink	Off-set	Drawing
Heat Treat	Cut Too Short	Mislabeled	Finish
Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Mistread
Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence

OTHER :

172555

DART AEROSPACE LTD		Work Order:	169901
Description: EAPS P2 Engine Fitting		Part Number:	D4931-5
Inspection Dwg: D4931 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	N/A	1-1/16-12 UN 2A	✓		MJP-04	vern
37°	+/-0.5°	37°	✓			
0.185	+/-0.010	0.185	✓			
0.315	+/-0.010	0.313	✓			
0.424	+/-0.010	0.420	✓			
0.250	+/-0.010	0.250	✓			
0.938	+/-0.010	0.934	✓			
1.927 Ref	+/-0.010	1.930	✓			
0.25	+/-0.030	0.253	✓			
0.13	+/-0.030	0.129	✓			
0.907	+/-0.010	0.907	✓			
0.078	+/-0.010	0.076	✓			
Ø0.063	+0.004/-0.001	0.065	✓			
0.13 x 45°	+/-0.030 x +/-0.5°	0.130 x 45°	✓			
0.34	+/-0.030	0.340	✓			
0.25	+/-0.030	0.253	✓			
Ø0.238	+0.005/-0.001	0.239	✓		Caliper	J.L.L.
35°	+/-0.5°	35°	✓		MJP-04	vern
0.532	+/-0.010	0.532	✓			
1.063	+/-0.010	1.062	✓		MJP-04	vern
0.513	+/-0.010	0.513	✓			
0.749	+/-0.010	0.746	✓		MJP-04	vern
1.025	+/-0.010	1.025	✓			

Measured by:	ASD/J.L.L.	Audited by:	ML	Preliminary Approval:	
Date:	18/03/04 (18-03-15)	Date:	18/03/27	Date:	
Rev	Date	Change	Revised by	Approved	
A	14.06.24	New Issue	KJ		